MARINE & STRUCTURAL FABRICATION

SAFRA ALUMINIUM FILLERS

MIG wire and TIG rods for boatyards, ferry builders and aluminium fabricators.

MADE IN ITALY · EU MANUFACTURE



Choose By Application

What you need	Selection detail	Page
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Select a filler for the joint	Alloy, temper and service conditions	04
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Ordering & Technical Advice

Give us the Safra grade, process, diameter, pack format and quantity. For class-controlled work, include the parent alloy, required approving body and the WPS so we can provide the certificate for your application.

Ask R H Davey about your application

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MARINE AND OTHER THIRD-PARTY APPROVALS

MIG Approvals

Current approvals for the listed Safra grade, diameter and shielding gas. For class-controlled work, request the certificate that covers your joint procedure.

Grade	Approving body	Diameter (mm)	Shielding gas	Certificate no. / expiry
5183	ABS	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1	On request
5183	DNV	0.8, 1.0, 1.2, 1.6	I1	On request
5183	Lloyd's Register	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1 and I3[1]	On request
5183	RINA	0.8, 1.0, 1.2, 1.6	I1	On request
5183	DB	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1	On request
5183	VdTÜV	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1	On request
5183	Bureau Veritas	1.2, 1.6	I1	On request
5183	ClassNK	0.8, 1.0, 1.2, 1.6	I1	On request
5356	ABS	0.8, 1.0, 1.2, 1.6	I1	On request
5356	DNV	0.8, 1.0, 1.2, 1.6	I1	On request
5356	Lloyd's Register	0.8, 1.0, 1.2, 1.6	I1	On request
5356	RINA	0.8, 1.0, 1.2, 1.6	I1	On request
5356	DB	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1	On request
5356	VdTÜV	0.8, 1.0, 1.2, 1.6, 2.0, 2.4	I1	On request
5356	Bureau Veritas	1.2, 1.6	I1	On request
5356	ClassNK	0.8, 1.0, 1.2, 1.6	I1	On request

[1] Safra lists I3 in addition to I1 for all six 5183 MIG diameters in the Lloyd's Register row.

For 5556 and other combinations outside this table, ask us to check coverage for your exact grade, process, diameter and shielding gas.

Approval certificates available on request.

Safra approval matrix

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MARINE AND OTHER THIRD-PARTY APPROVALS

TIG Approvals

Current approvals for the listed Safra grade, diameter and shielding gas. For class-controlled work, request the certificate that covers your joint procedure.

Grade	Approving body	Diameter (mm)	Shielding gas	Certificate no. / expiry
5183	ABS	2.4, 3.2, 4.0, 5.0	I1	On request
5183	Lloyd's Register	2.4, 3.2, 4.0, 5.0	I1	On request
5183	DB	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	I1	On request
5183	VdTÜV	2.0, 2.4, 3.2, 4.0, 5.0	I1	On request
5183	Bureau Veritas	2.4, 3.2, 4.0, 5.0	I1	On request
5183	ClassNK	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	I1	On request
5356	DB	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	I1	On request
5356	VdTÜV	2.0, 2.4, 3.2, 4.0, 5.0	I1	On request
5356	ClassNK	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	I1	On request

For 5556 and other combinations outside this table, ask us to check coverage for your exact grade, process, diameter and shielding gas.

Approval certificates available on request.

Safra approval matrix

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FILLER METAL SELECTION

Compare The Marine Alloys

Start with the parent-alloy designation and temper, required joint strength and the finished assembly's service conditions.

Alloy	Safra minima[1]	What it does well	Anodised appearance
5183	275 / 130 / 18	Strength and elongation for qualified 5083 and 5383 marine structures. Al-Mg-Mn filler for seawater service with compatible high-Mg plate.	Generally a closer colour match to Al-Mg parent metal than Al-Si filler.
5356	250 / 120 / 18	General marine fabrication with compatible alloys such as 5086. Check allowable strength when a plate specification or design calls for a higher-strength deposit.	Often selected where a 6xxx assembly will be anodised and the joint permits Al-Mg filler.
5556	Ask for values	Higher-strength Al-Mg-Mn-Ti option for specified marine and structural joints. Qualify joint strength, ductility and corrosion performance for the application.	Al-Mg deposit. Qualify appearance using a coupon if the weld remains visible.
4043	120 / 40 / 8	Free-flowing Al-Si filler for compatible 6xxx joints and Al-Si castings. Use where ease of welding and resistance to solidification cracking matter.	Typically darkens after anodising. Test against the required finish.

[1] Rm tensile strength / Rp0.2 proof strength (MPa) / A elongation (%). These are Safra weld-metal minima. Design the joint using the governing welded-joint allowables and the required procedure tests.

Appearance, Strength & Corrosion

Choose the filler and test the joint in the specified temper and condition. For marine work, assess weld and heat-affected zone (HAZ) performance, especially where the joint will see seawater, cyclic load or a visible anodised finish.

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MARINE FABRICATION

Match The Parent Alloy

Use the alloy pair and service requirements to shortlist the filler. Use the approved welding procedure for production work.

Parent material	Selection starting point	Engineering checks
5083 or 5383 to itself	5183 is a starting point for load-bearing marine plate. Use 5556 where specified and qualified.	Use 5356 only where the design allows its joint properties. Avoid Al-Si 4043 on these high-Mg alloys.
5086 to itself	5356 is a common choice. Consider 5183 where higher strength is required and the procedure qualifies it.	Confirm the specified alloy and temper and check the required strength and corrosion performance.
6082 to itself	4043 is a starting point for crack resistance. 5356 can suit a different strength or anodised finish requirement, where qualified.	Allow for softening in the heat-affected zone of heat-treated 6082. Joint tests and design allowables govern.
5083, 5086 or 5383 to 6082	Use the approved dissimilar-alloy procedure. Shortlist a compatible Al-Mg filler where the joint specification allows.	Avoid 4043 on high-Mg parent material. Check dilution, strength, restraint and service exposure for the specific pairing.

Sustained Service Above About 65°C

High-Mg alloys can sensitise with prolonged temperature exposure. A magnesium-rich phase can form at grain boundaries and increase susceptibility to intergranular attack and stress-corrosion cracking, especially in chloride service. Review filler, parent plate and HAZ together. For qualified 5454 applications, lower-Mg 5554 is an option. Check strength and corrosion requirements before any substitution.

For class-controlled work, confirm the specified parent grades, filler certificate scope and welding procedure qualification before ordering.

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WORKSHOP SETUP

Feed Aluminium MIG Wire

Soft aluminium wire feeds most consistently through a correctly matched drive, liner and contact tip.

Setup point	What to specify
Torch and wire path	Use push-pull for long reaches or regular production. A spool gun shortens the feed path and suits local jobs and compatible small spools. Keep a push-only lead short and as straight as practical.
Drive rolls and spool brake	Use smooth U-groove drive rolls sized to the wire. Set the lowest pressure that feeds reliably. Apply just enough spool brake to prevent overrun.
Liner and contact tip	Use an aluminium-compatible PTFE or nylon liner and keep it dedicated to aluminium. Fit an aluminium-rated tip matched to the wire size and torch maker's recommendation. Correct clearance allows for heat expansion.
Wire diameter and current	0.8–1.0mm suits the lower average-current end and thinner material. 1.2mm is a starting point for general plate and section work. 1.6mm suits higher-current deposition on heavy sections. Check the machine programme and qualified procedure together.

Shielding Gas For Aluminium

Argon (I1) is the starting point for MIG and TIG. A qualified argon/helium mix (I3) can increase heat input and help achieve fusion on thicker plate. Check the mix, gas flow, transfer mode and approval scope against the WPS. Keep the joint shielded from draughts.

If feed is erratic, check drive pressure, spool brake, liner, tip and lead bends before adjusting the welding programme.

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WORKSHOP PRACTICE

Prepare, Store & TIG Weld

Good preparation reduces contamination, oxide inclusions and hydrogen porosity. Keep the filler as clean as the parent material.

Step	Workshop guidance
Degrease first	Remove oil, grease and moisture from both sides of the joint and nearby surfaces. Use an approved residue-free cleaner and allow the joint to dry.
Remove oxide	Use a clean stainless-steel brush dedicated to aluminium, or the specified mechanical or chemical preparation. Prepare shortly before welding and keep iron-bearing debris away.
Store filler dry	Keep spools and rods in closed, dry packaging. Let cold packs reach workshop temperature before opening to prevent condensation. Cover opened spools between jobs and protect rod surfaces from handling contamination.
Choose TIG rod size	A smaller rod gives finer control on thin edges and open roots. A larger rod adds metal faster on suitable joints with adequate heat input. Select diameter against the joint preparation and procedure.
Select the TIG setup	On conventional AC TIG, use the specified balance and shielding gas. Keep the rod end in the shielding envelope and use a clean, correctly prepared tungsten.





For rod ordering, use the grade tables from page 8. Safra lists 1,000mm rods in 10kg cartons for the grades that specify those formats.

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ALUMINIUM GRADES

Commercially Pure & Al-Cu

1xxx fillers for commercially pure aluminium and 2319 for selected heat-treatable Al-Cu alloys.

1070 AWS ER1070 / R1070 · S Al 1070 (Al99.7)



Commercially pure aluminium filler for 1xxx material such as Al99.5 and Al99.7. Use for specified chemical, electrical or food-industry fabrication.

Rm 60 MPa · A 35%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

1450 AWS ER1450 / R1450 · S Al 1450 (Al99.5Ti)



Titanium-refined filler for commercially pure aluminium. Use where the procedure specifies a Ti-bearing filler for grain refinement.

Rm 65 MPa · Rp0.2 20 MPa · A 35%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

2319 AWS ER2319 / R2319 · S Al 2319 (AlCu6MnZrTi)



Heat-treatable aluminium-copper filler for 2219 and specified 2014, 2036 or Al-Cu castings. Confirm the post-weld heat treatment in the procedure.

Rm 140 MPa · Rp0.2 70 MPa · A 12%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

Rm = tensile strength. Rp0.2 = proof strength. A = elongation. Values are Safra weld-metal minima.

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ALUMINIUM GRADES

Al-Si & Casting Repair

Compare a general-purpose Al-Si filler, a higher-silicon brazing alloy and a grade for specific castings.

4043 AWS ER4043A / R4043A · S Al 4043A (AlSi5(A))



Free-flowing silicon filler for compatible 6xxx extrusions and Al-Si alloys containing up to 7% silicon. The weld may anodise dark grey.

Rm 120 MPa · Rp0.2 40 MPa · A 8%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

4047 AWS ER4047A / R4047A · S Al 4047A (AlSi12(A))



Higher-silicon, lower-melting filler for aluminium brazing and specified sheet, extrusion or casting work. Expect a colour difference after anodising.

Rm 130 MPa · Rp0.2 60 MPa · A 5%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

4008 S Al Z (AlSi7Mg)



Controlled-impurity filler for joining or repairing 356.0, A356.0 and A357.0 castings. Safra states its chemistry meets AMS4181 requirements.

Shielding gas in grade sheet: I1 (argon).

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	1.0, 1.2, 1.6	D300 / K300 / KS300 · 6 or 7 kg
MIG	1.0, 1.2, 1.6	Drum · 80–250 kg[1]
TIG	1.6, 2.0, 2.4, 3.2, 4.0	Rod length and carton weight on enquiry

Technical datasheet

[1] Safra quotes an 80–250 kg drum range for this grade. Confirm the exact drum and diameter.

4043 in 0.8mm: Safra's public matrix includes this MIG diameter. Ask for the current spool options.

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ALUMINIUM GRADES

Al-Mg Fabrication

Select by parent alloy, magnesium content and the temperature the finished joint will see in service.

5554 AWS ER5554 / R5554 · S Al 5554 (AlMg2.7Mn)



Select for 5454 and specified 5454-to-6xxx joints in elevated-temperature service. Confirm the design temperature and procedure before ordering.

Rm 215 MPa · Rp0.2 100 MPa · A 18%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

5754 AWS ER5754 / R5754 · S Al 5754 (AlMg3)



AlMg3 filler for compatible aluminium-magnesium sheet and fabrications. Use for specified 5754 work in general fabrication and transport.

Rm 190 MPa · Rp0.2 80 MPa · A 20%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet Italian-language manufacturer sheet

5356 AWS ER5356 / R5356 · S Al 5356 (AlMg5Cr(A))



General-purpose AlMg5 filler for compatible aluminium-magnesium alloys. Typical uses include tanks, marine fabrication, rail and automotive work.

Rm 250 MPa · Rp0.2 120 MPa · A 18%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

Rm = tensile strength. Rp0.2 = proof strength. A = elongation. Values are Safra weld-metal minima.

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ALUMINIUM GRADES

Marine & Structural Al-Mg

Compare specified grades for marine, offshore and structural fabrication, including higher-strength joints.

5183 AWS ER5183 / R5183 · S Al 5183 (AlMg4.5Mn0.7(A))



Al-Mg-Mn filler for specified 5083 work, shipbuilding and offshore fabrication. Use where the procedure calls for this combination of strength and seawater corrosion resistance.

Rm 275 MPa · Rp0.2 130 MPa · A 18%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

5087 AWS ER5087 / R5087 · S Al 5087 (AlMg4.5MnZr(A))



Zirconium-refined filler for compatible Al-Mg alloys. Use for specified marine, tank and transport work where bend performance and corrosion resistance matter.

Rm 285 MPa · Rp0.2 140 MPa · A 18%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

5556 AWS ER5556 / R5556 · S Al 5556 (AlMg5Mn1Ti(A))



Al-Mg-Mn-Ti filler for shipbuilding and structural joints requiring higher mechanical properties than typical 5183 deposits. Check that the procedure specifies 5556.

Shielding gas in grade sheet: I1 (argon).

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	1.0, 1.2, 1.6	D300 / K300 / KS300 · 6 or 7 kg
MIG	1.0, 1.2, 1.6	Drum · 80–250 kg[1]
TIG	1.6, 2.0, 2.4, 3.2, 4.0	Rod length and carton weight on enquiry

Technical datasheet

[1] Safra quotes an 80–250 kg drum range for this grade. Confirm the exact drum and diameter.

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ALUMINIUM GRADES

Specialist Structural Al-Mg

Check the full designation where the specification calls for 5556A or Safra's proprietary AlMg6Zr grade.

5556A AWS ER5556A / R5556A · S Al 5556A (AlMg5Mn1(A))



High-strength filler for compatible Al-Mg parent alloys containing up to 5.3% Mg. Use when 5556A is specified for structural or defence fabrication.

Rm 290 MPa · Rp0.2 145 MPa · A 17%

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	D300 / K300 / KS300 · 5, 6 or 7 kg
Mini-MIG	0.8, 0.9, 1.0, 1.2, 1.6	D100 · 0.5 kg / D200 · 2 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000mm rods · 10kg carton

Technical datasheet

SAFRA 66 S Al Z (AlMg6Zr)



Safra's Al-Mg-Zr structural filler where strength, ductility and corrosion resistance must be balanced. Specify SAFRA 66 and qualify the joint for its service conditions.

Indicative Rm 280–365 MPa · yield strength 140–200 MPa

FORM	DIAMETER (mm)	FORMAT / NET PACK
MIG	1.2, 1.6	D300 · 6 or 7 kg / K300 or KS300 · 7 kg
TIG	1.6, 2.0, 2.4, 3.2, 4.0	Length on enquiry · 10kg carton
MIG	On enquiry	Drum on enquiry · confirm pack and diameter

Technical datasheet

Check Service Temperature

Safra advises against prolonged elevated-temperature service for 5xxx fillers containing more than 3% Mg. Specify the design temperature and select the filler against the welding procedure.

Rm = tensile strength. Rp0.2 = proof strength. A = elongation. Values are Safra weld-metal minima unless marked indicative.

5556A in 1.2mm: VdTÜV approval for MIG with I1 shielding gas. Certificate details available on request.

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PACKAGING AND DIMENSIONS

Spools, Rods & Drums

Safra's packaging range. Check the alloy's grade table for published combinations and confirm any special format on enquiry.



D300 spool





Eco Pak65 drum

Safra format	Filler diameter (mm)	Pack dimensions (mm)	Net weight
D100 (S100)	0.8, 0.9, 1.0, 1.2, 1.6	100 × 45	0.5 kg or 1 lb
D200	0.8, 0.9, 1.0, 1.2, 1.6	200 × 45	2 kg
D300 (S300)	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	300 × 100	5, 6, 7, 9 kg
K300 (B300)	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	300 × 98	5, 6, 7 kg
KS300 (BS300)	0.8, 0.9, 1.0, 1.2, 1.6, 2.0, 2.4	300 × 100	5, 6, 7, 9 kg
D350 (S350)	1.2, 1.6, 2.4	350 × 185	20 kg
K400	1.2, 1.6, 2.4	400 × 200	40 kg
TIG carton	1.6, 2.0, 2.4, 3.2, 4.0, 5.0	1,000 rod length	10 kg
Eco Pak	1.0, 1.2, 1.6	780 × 520	80 kg
Eco Pak65	1.0, 1.2, 1.6	930 × 650	200 kg
Eco Pak65BA	1.0, 1.2, 1.6	550 × 650	100 kg
Eco Pak75	1.0, 1.2, 1.6	1,130 × 750	250 kg
Eco Pak75BA	1.0, 1.2, 1.6	550 × 750	125 kg

Spools are shown as diameter × width. Drums are shown as height × diameter.

Safra packaging specifications Aluminium safety data · Rev. 07

Specialist grade enquiries: Safra's safety data identifies ER3103 and ER4145. For either grade, give the process, diameter and required pack format so we can check availability.

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BULK WIRE HANDLING

Drum Feed Accessories

Match the accessory to the drum diameter, alloy family and feed system. Where Safra shows several codes, confirm the exact assembly with your supplier.





5 rollers per plane



Accessory / fitment	Safra part number
Plastic hood · 520 mm	9910000003
Plastic hood · 650 mm	9910000005
Plastic hood · 750 mm	9910000027
Top carton rise · 650 mm	9910000084
Top carton rise · 750 mm	9910000085
Plastic cover for carton rise · 650 mm	9910000086
Plastic cover for carton rise · 750 mm	9910000090
Centring device	9910000013
Single-cone pay-off · 5xxx aluminium	9910000010 / 9910000015 / 9910000014 / 9910000026
Double-cone pay-off · 4xxx aluminium	9910000008 / 9910000007
Inner orbital arm + PTFE liner · 520 mm	9910000018
Nylon balls	9910000025
Wooden balls · 40 or 55 mm	9910000006 / 9910000024 / 9910000022 / 9910000023
Two-plane straightener · 5 rollers per plane	9910000016
Two-plane straightener · 7 rollers per plane	9910000017
Wire conduit	9910000011
Wire connector · all Safra drum types	9910000009

For a feed-system quote, supply the drum model, wire grade and diameter, pay-off setup and required conduit length. Confirm compatibility for copper drums and for 2xxx aluminium.

Safra drum accessories and setup tutorials

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